

# Work Order ID 63590

Thursday, November 04, 2010 1:07:34 PM



Page 1

Item ID: D2938-2

Revision ID:

Item Name: Saddle RH Out, 206

Start Date: 11/4/2010 Start Qty: 6.00

Required Date: 11/25/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

*PR*

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

*ant 10/12/06*

*6 0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*ant 10/12/06*

*6 0*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*ant 10/12/06*

*6 0*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Stop



Cust Item ID:

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Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

BA 10/12/07

6

0

Memo

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

6 BL 10-12-7.

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

START TIME:

9:30

OVEN TEMPERATURE:

320° FINISH TIME:

10:00

6 BL 10-12-7.

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 11/25/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

3) M

10/12/07

0.00

6

0

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 429

Memo

0.00

0.00

Rec'd 10/12/08 (6)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/12/08 JF  
MF  
10-12-08

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# Picklist Print

Thursday, November 04, 2010 1:07:37 PM

Page 1

Work Order ID: 63590

Parent Item: D2938-2

Parent Item Name: Saddle RH Out, 206



Start Date: 11/4/2010

Required Date: 11/25/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	24.0000	1	6			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT042

24

61250

24

B63560 XL

and 10/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	63590
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By 5	Date 6
A	0.100	0.140	Vern ML-7	.112	.112	.112	.112	.115	.115
B	0.100	0.140		.112	.112	.112	.112	.115	.115
C	0.100	0.140		.117	.112	.112	.114	.115	.115
D	0.210	0.230		.222	.222	.222	.222	.222	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510	.510
I	1.572	1.582		1.576	1.576	1.576	1.576	1.576	1.576
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.260	.260	.260	.260	.260	.260
L	0.312	0.317		.314	.314	.314	.314	.314	.314
M	0.235	0.240		.236	.237	.237	.237	.237	.237
N	0.100	0.140	Micr 118-620	.116	.116	.116	.115	.115	.115
O	0.540	0.560	Vern ML-7	.546	.550	.551	.551	.551	.551
P	0.490	0.510		.498	.501	.500	.500	.501	.501
Q	3.715	3.725		3.718	3.718	3.718	3.718	3.718	3.718
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.254	.252	.253	.253	.256	.253
T	0.100	0.180		.140	.140	.140	.140	.140	.140
U	1.625	1.635		1.628	1.628	1.628	1.628	1.628	1.628
V	1.362	1.372		1.366	1.366	1.366	1.366	1.366	1.366
W	0.316	0.321		.317	.317	.317	.317	.317	.317
X	1.250	1.270	Test indicator	1.259	1.260	1.259	1.259	1.257	1.260
Y	1.565	1.585		1.574	1.575	1.575	1.574	1.572	1.575
Z	0.178	0.198	Rad gage REF	.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	10/12/06

Audited by:	A. A
Date:	10/12/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

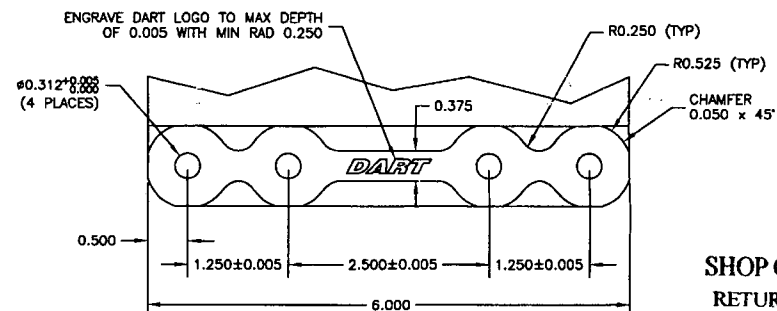
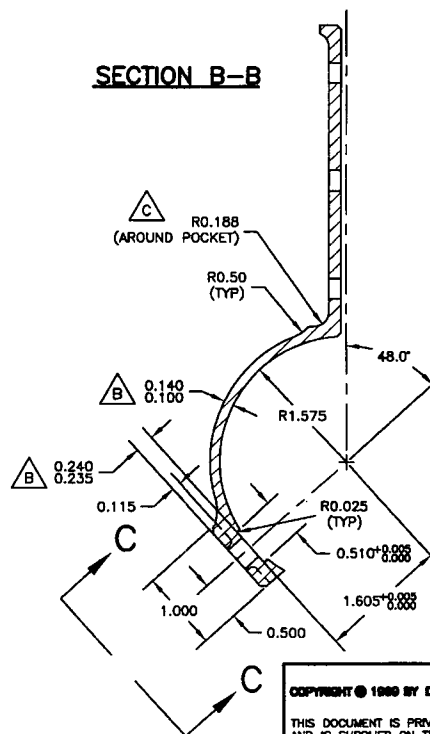
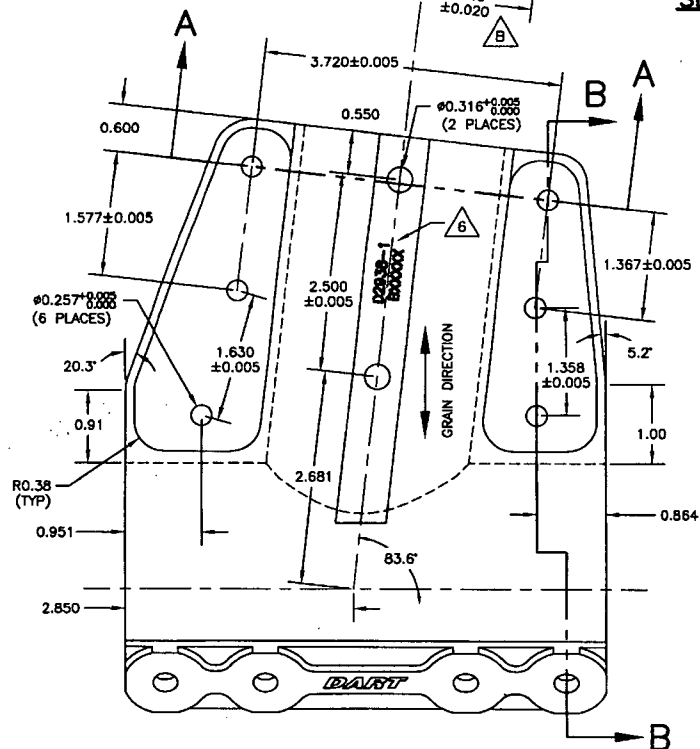
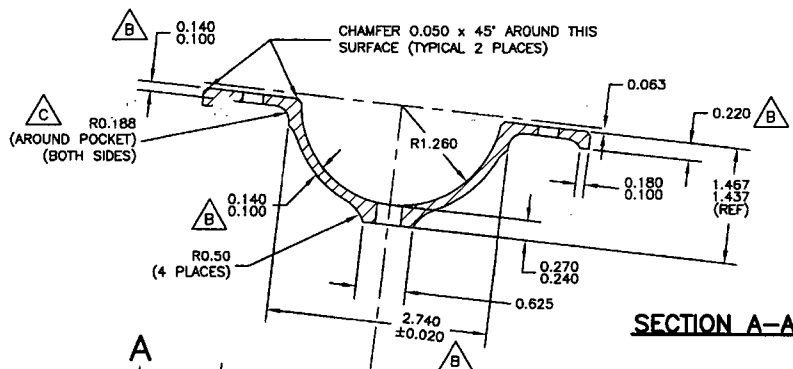
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SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43590

D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
DRAWING NO.	D2938	REV. C
		SHEET 1 OF 1
		SCALE 2:3

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07.02.12

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